

Date: Monday, 07/07/2008 4:16:07 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BK117 SKIDTUBE ASSEMBLY
Job Number :	40333		
Estimate Number :	12899		
P.O. Number :		Part Number :	D117762011
This Issue :	07/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	N/A PRELIM <i>JE</i>
First Issue :	1/1	Project Number :	N/A
Previous Run :	40332	Drawing Revision :	A PRELIM <i>JE</i>
Type :	SKIDTUBES	Material :	
Written By :		Due Date :	18/07/2008
Checked & Approved By :	<i>JUD 08.7.07</i>	Qty:	1 Um: Each
Comment :	Est Rev:A 07.06.11 New Issue EC Est Rev:B 08-02-22 change to revA DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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*JUD 08.7.24***Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D117-762-011 CHG001

S 08/06/05

2.0	40333A	BK117 SKIDTUBE ASSEMBLY
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**Comment:** Sub-Component BK117 SKIDTUBE ASSEMBLY1 x D117-762-041 Batch: *40333A**SC*

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D35121	Wearplate
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WEARPLATE

Batch: *39020**JS 08/07/10 (X1)*

5.0	AN960JD10L	Washer
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**Comment:** Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Batch: *M104885**JS 08/07/10 (X1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 4:16:08 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40333

Part Number: D117762011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	AN3C4A	BOLT
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

BATCH: M108568 *New Batch*

7.0	AN451A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

BATCH: 108071

8.0	D2972	Bushing
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bushing

BATCH: 12103

9.0	MS21042L4	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

BATCH: M107478

10.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

11.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D117-762-011

Location:

PPP Rev: Draft

12.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Handwritten: B 40333 A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 4:16:45 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BK117 SKIDTUBE ASSEMBLY
Job Number :	40333A	Part Number :	D117762041
Estimate Number :	12898	Drawing Number :	D3582 REVA PRELIM <i>B</i>
P.O. Number :		Project Number :	N/A
This Issue :	07/07/2008	Drawing Revision :	A PRELIM <i>B</i>
Prsht Rev. :	NC	Material :	
First Issue :	//	Due Date :	18/07/2008
Previous Run :	40332A	Qty:	1 Um: Each
Written By :			
Checked & Approved By :	<i>JUL 08-7-07</i>		
Comment :	Est Rev:A 07.06.11 New Issue EC Prototype for engineering use only (LG0005-32910) Est Rev:B 08-02-22 change to revA as per dwg DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROLPhotocopy bluefile & type labels per PPP D117-762-041 CHG001 *N/A*

2.0	D2962150	3.540 Outer Tube, Extrud
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-150 Extrusion

*B28672**DP8-7-10*

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes.

DP8-7-10

4.0	BENDING	BENDING MACHINE - SKIDTUBES
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**Comment:** BENDING MACHINE

Bend tube as per program on CNC Bender and Dwg D3582. Use 5/16" locator pin on buggy "A".

DP8-7-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		Section B-B detail holes is incorrect.						

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 4:16:45 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40333A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Cut Fwd end of the tube using DT8185
- 2-Cut Aft end at VC using DT8185
- 3-Deburr ends
- 4-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE***
- 5-Locate DT 8973 & Drill Ground wire hole on top of Tube.
- 6-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill.
- 7-Drill pilot holes for wearplates using DT8974
- 8-Open wearplate holes and ground wire holes to Ø19/64" (0.297") as per Dwg D3582.
- 9-Open Aft Cap holes using .209" drill.
- 10-Deburr holes.

8-7-11

8-8-14

PC

6.0

D2964

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

214101 BE 8-7-14

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE.1

1-Weld fwd cap D2964 per dwg D3582 and QSI 004

A/R AL ROD

Batch:

m108096/m107877 BE 8-7-14

2-Grind flush

BE 8-7-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D117-762-011 PAR #: 08-025 Fault Category: Prod / Assembly Engineering Coordinator: [Signature] NCR: Yes No DQA: D Date: 08/08/20
QA: N/C Closed: D Date: 08/08/20

NCR: <u>40333A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-07-14	5.0	Section B-B R the drilling depth is incorrect. Holes were 35° from the horizontal CL, instead of the vertical, as the tooling DT 8973	<u>[Signature]</u> 081042	Fill in holes on the tube. correct the tooling per PAR 08-025 M108096	BE 08-07-14	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u>
		R.C: Incorrect holes in tooling						

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 4:16:45 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40333A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

10008-14 (1)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10008-14 (1)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AM 7-8-14
DP 8-8-15

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 7-8-14

12.0

D2971

Cross Bolt Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cross Bolt Spacer
batch *39011*

(1) M 7-8-18

13.0

D2973

Cross Bolt Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cross Bolt Spacer
Batch: *B14631*

(2) M 7-8-18

14.0

D36621

Crossbolt Spacer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

SPACER
batch *B 39 585*

(3) M 7-8-18

15.0

D36623

Crossbolt Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SPACER
batch *37190*

(1) M 7-8-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Monday, 07/07/2008 4:16:45 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40333A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

D35841

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEB

40362

SL 8-8-15

17.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open X-Bolt holes to .750"(4Places) as per Dwg D3582, section B-B

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3582 & QSI 015

A/R 241 Sike Flex Batch: 18801

Exp Date: 8-10-1

5-Weld x-bolt spacers(D2973) as per Dwg D3582,section B-B.

A/R AL ROD

Batch: M108096

6-Grind welds flush

Tools: E

18.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20.0

POWDER COATING

PRESSURE
WASH

POWDER COATING

08-08-19 x 1.0



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:30
320 OF
4:00

M-1 08/08/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40333A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-08-20

22.0

ALS41032130

Insert



Comment: Qty.: 36.0000 Each(s)/Unit Total : 36.0000 Each(s)

Insert

Batch: M 105819

BR

23.0

ALS4428165

Inserts



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inserts

batch M 6989

***same as ALS7-428-165 QSI 0017 ***

BR

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Wearplate & Ground Wire inserts as per Dwg D3582.

BR 08-08-20

25.0

D2965

Cap, 105 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B 41523

BR

26.0

D35083

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B 38431

BR

27.0

D35089

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B 40359

BR

BR 08-08-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40333A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D350811

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Batch:

WEARPLATE

B 36415

BR.

29.0

D350813

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch:

B 38528

BR

30.0

D35583

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B 38613

BR.

31.0

D35589

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B 40361

BR.

32.0

D355811

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B 40399

BR.

33.0

D355813

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B 36418

BR

34.0

AN3C4A

BOLT



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

BOLT

Batch:

M 108599

BR

BR 080820

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40333A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN3C5A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: *M108744*

BL

36.0

AN44A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch *M106918*

BL

37.0

AN960C10L

washer



Comment: Qty.: 28.0000 Each(s)/Unit Total:- 28.0000 Each(s)

washer

Batch: *M108618*

BL

38.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch *M104885*

BL

39.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch *M108138*

BL

40.0

D3492049

Plug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLUG ASSEMBLY

batch *B37288*

BL

41.0

D3492051

Plug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLUG ASSEMBLY

batch *B37289 39723*

BL

BL 08-08-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40333A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

D3492053

Plug Assembly



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

PLUG ASSEMBLY

batch

B 3907

BL

43.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign objects

2-Install Aft cap as per Dwg D3582, Detail "C"

A/R 241 Sika Flex

Batch:

M108801

Exp Date:

08-10

3-Install Wearplates as per Dwg D3582 ,

Note:Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582

*****Do not install bolts where indicated on Dwg(Note #6)*****

A/R 241 Sika Flex

Batch:

M108801

Exp Date:

08-10

4- Wing Walk as per Dwg D3043 and QSI 005 4.4

FL 08/08/20 (1)

44.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/21 (1)

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D117-762041

Location:

PPP

PPP Rev:

8/8/25

(1)

30

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26 (1)

Job Completion



u 08.08.26

Dart Aerospace Ltd

W/O: /		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

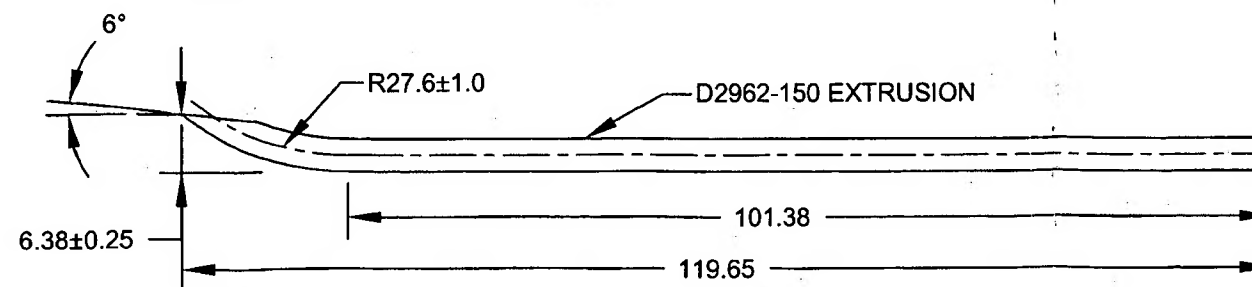
NOTE: Date & initial all entries

PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

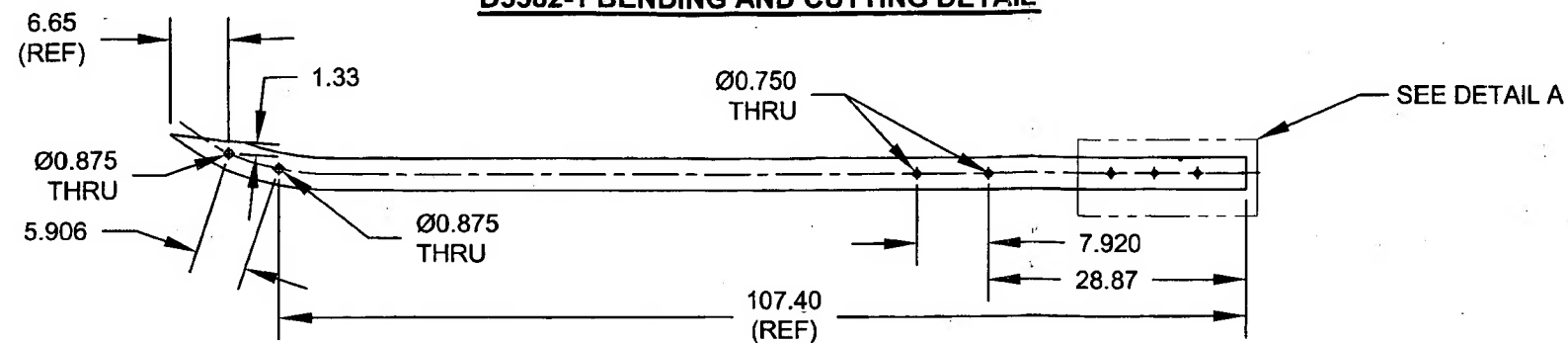
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

GENERAL NOTES:

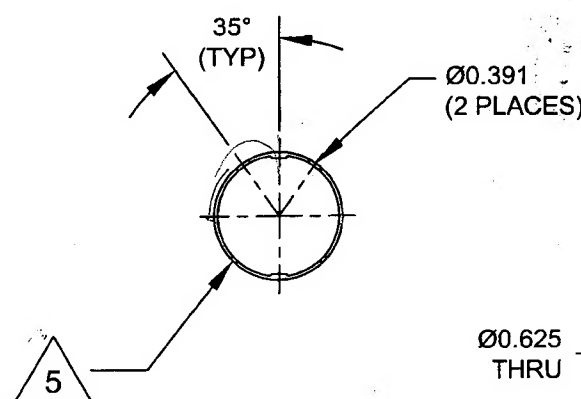
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004.
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- FINISH:
 - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
 - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 - ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4



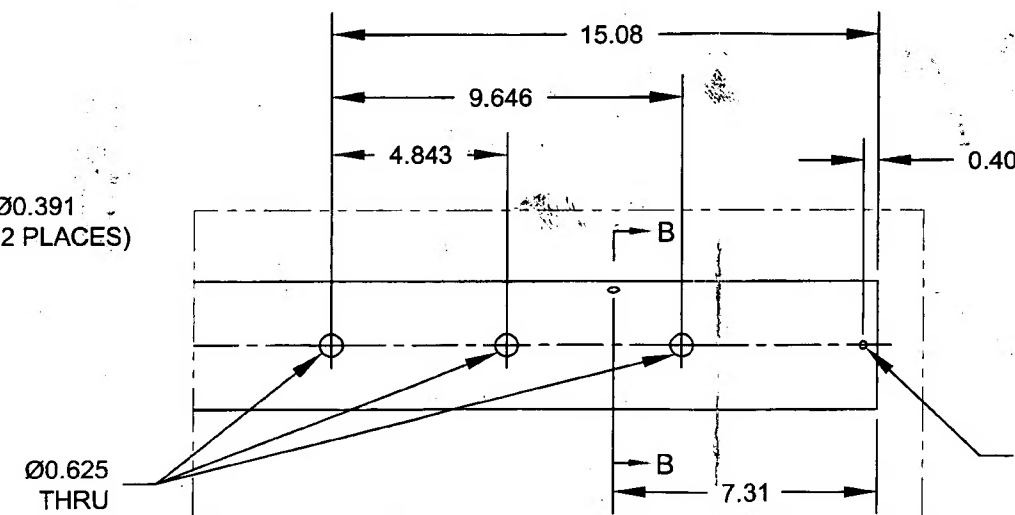
D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 1:5

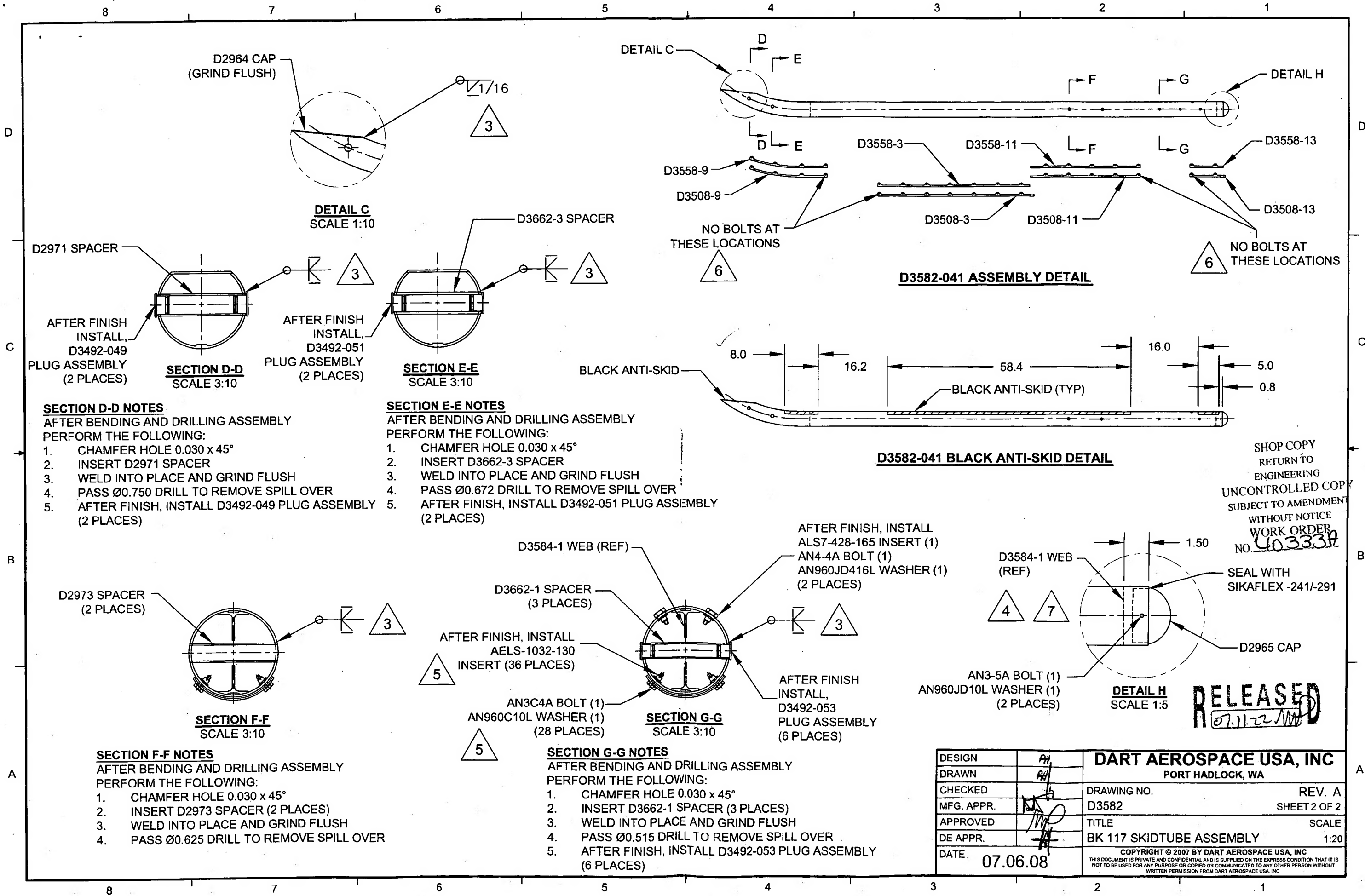


DETAIL A
SCALE 1:5

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A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3582	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	BK 117 SKIDTUBE ASSEMBLY	1:2
DATE	07.06.08	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC	
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NO. 148

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 38388A
Part number: D117 762 OUI
Description: Skid tube Bk117
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat Duval Date of Test Coupon 08-04-14
Welder Barclay Elliot Date of Test Coupon 08-07-14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld